

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006717**Date Inspected:** 12-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 9-

This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations after weld repair. Testing was performed in accordance with Caltrans UT procedure "Phased Array Testing" for detection of planar discontinuities (cracks) in PJP welds.

Results of Deck Panels evaluated are as follows:

DP123-002 (9BW): 43 locations tested with 3 rejected (R1).

DP504-001 (9EE): 3 locations tested with 0 rejected (R1).

This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations. Caltrans NDT personnel performed conventional ultrasonic testing of tack welds. Tack weld locations that exhibited crack like indications in the area of interest were marked and recorded prior to PAUT. PAUT was performed in accordance with Caltrans UT procedure "Phased Array Testing" for detection of planar discontinuities (cracks) in PJP welds. Results of Deck Panels evaluated are as follows:

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DP369-001 (9EE) 33 locations tested with 14 locations rejected.

Bay 11-

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as East Tower Lift 2 Skin A to E corner weld joints, ESD1-TL7 B/L- 1A.

OBG Trial Assembly Area-

QA Inspector observed the following work in progress: FCAW welding of weld joints 002, 003, 004 located on OBE 2A-002 . ZPMC welders were identified as 220067, 048801 and 202841 . ZPMC QC is identified as Wu Zhi Cheng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231T.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversations occurred between QA and QC on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134 8257 0045, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
